



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3198-1
Job Sheet 169578



Part No: D3198-1

Job Qty: 8 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 1/5/18

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Hawker Pacific Pty Ltd (CHAWK02)

Locked Bag 2067 Wetherill Park, NSW, 1851 Australia ph:011 61 2 9708 8551

Note: DWG REV A IPP: A 03.11.11 New Issue KJ/RF IPP Rev:B Now on Waterjet 07-01-09 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		1/4/18	0.00	0.00	Start Up Waterjet		OK 17/12/18
100	Waterjet	8 pcs		1/4/18	0.00	0.52	Waterjet1		OK 17/12/18
120	QC	8 pcs		1/4/18	0.00	0.00	QC8		38
130	Brake NC	8 pcs		1/4/18	0.03	0.50	Brake NC 1		38
140	QC	8 pcs		1/4/18	0.00	0.00	QC5		38
150	Powdercoat	8 pcs		1/5/18	0.00	0.15	Powdercoat3		BK 18 Dis 17
160	QC	8 pcs		1/5/18	0.00	0.00	QC3		38 11 JAN 18 2018
170	Packaging	8 pcs		1/5/18	0.00	0.00	Packaging3-1	57 ea	AT 9-89 18-01-18
180	QC21-SA	8 Ea		1/5/18	0.00	0.00	QC21		JAN 1 2018

Part Op 100 - 1-Cut as per Dwg D3198

Descriptions: 130 - 1-Deburr if necessary 2-Form as per Dwg D3198

150 - START TIME: 11:00 O.V.T. 30° FINISH: 11:50.

M B6370

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S11GA	1	91	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.266inches + 0.006 - 0.001	0.272 0.265		
2	Fitting	4.280inches ± 0.010	4.290 4.270		
3	Fitting	2.500inches ± 0.010	2.510 2.490		
4	Fitting	3.420inches ± 0.010	3.430 3.410		
5	Fitting	0.400inches ± 0.010	0.410 0.390		
6	Fitting	0.400inches ± 0.010	0.410 0.390		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Jet ☐ Engineering ☐ por. ☐ Quality ☐ ing ☐ Other ☐ lier ☐ MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																			
Date : _____ Step #: _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE S023586																																					
Description Work Order Deviation																																							
Root Cause <table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;">Environment ☐</td> <td style="width:33%;">No Re-verification ☐</td> <td style="width:33%;">Pressure/Forced ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td></td> </tr> </table>		Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Design ☐	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐		DART AEROSPACE S023586 Drill Holes ☐ Fitting Misaligned/off center ☐	
Environment ☐	No Re-verification ☐	Pressure/Forced ☐																																					
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DART AEROSPACE
S023586



Fitting

D3198 -- 1

PART NO:
Revision:
Operation:
Change No:

Start up Operation

Mfg Date: 12/16/17
Job No: 169578

- ☐ Positioned Wrong
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Drawing
- ☐ Finish
- ☐ Misread
- ☐ Turning Sequence

7	Fitting	3.880inches $\pm$ 0.010	3.890 3.870
8	Fitting	2.100inches $\pm$ 0.010	2.110 2.090
9	Fitting	3.020inches $\pm$ 0.010	3.030 3.010

Plex 12/13/17 4:45 PM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



Dart Hawkesbury
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Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D3198-1 Revision: Fitting														
180	QC21-SA	S023586	169578	8 Ea	0	S023586	ST021	Bin	Stock	12/16/2017	Issue Container			
Operation Totals:		1		8	0									
Part Totals:		1		8	0									
Part Number: M304S11GA Revision: 304/316 0.125 Sheet														
100	Receive sf	S023585	169578	0 sf	0	M138109	MAT020		Stock	12/16/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		2		8	0									

Plex 1/19/2018 8:49 AM Dart.Lajeunesse.Marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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